



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4766-041
Job Sheet 199362



Part No: D4766-041

Job Qty: 1 pcs

Part Name: Skidtube Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/20/19

Job Tracking No:

Due Date: 8/30/19

Created By: Jason Leroux

Type: SOLD

Description:

Note: DWG REV E IPP REV:A 13.04.17 NEW ISSUE DD VERF:JLM IPP REV:B 13.08.08 PB2 DD VERF:JLM IPP REV:B 13.08.26 PB3 DD VERF:JLM IPP REV:C 13.11.14 AS PER DWG REV.B DD VERF:JLM IPP REV:D 15.06.10 AS PER DWG REV.C DD VERF:JLM IPP REV:E 16.03.23 AS PER DWG REV.D DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
120	Skidtubes - 1	1 pcs	8/30/19		0.00	1.00	Skidtubes - 1			
							Skidtubes - 2			
							Skidtubes - 3			
							Skidtubes - 4			
							Skidtubes - 5			
							Skidtubes - 6			
							Skidtubes - 7			
140	QC 5	1 pcs	8/30/19		0.00	0.00	QC 5 - 10			
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			
							QC 5 - 24			
							QC 5 - 3			
							QC 5 - 43			
							QC 5 - 49			
							QC 5 - 51			
							QC 5 - 58			
							QC 5 - 68			
							QC 5 - 9			
							QC 5 - 50			
							QC 5 - 30			
							QC 5 - 40			
							QC 5 - 61			
							QC 5 - 81			
150	Handfinish - 1-1 Chemical-B4B	1 pcs	8/30/19		0.00	0.62	Handfinish - 1 - 1 - B4B			
							Handfinish - 1 - 2 - B4B			
							Handfinish - 1 - 3 - B4B			
							Handfinish - 1 - 4 - B4B			



Container No: S211646



Part: D4766-041

Job No: 199362

Serial No/Batch: S211646

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
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www.dartaerospace.com

Date: 09/05/19

SEP 05 2019
DAS
68
9-29

SEP 05 2019

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						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
160 QC 7	1 pcs	8/30/19	0.00	0.00		QC 7 - 10	
						QC 7 - 13	
						QC 7 - 14	
						QC 7 - 15	
						QC 7 - 17	
						QC 7 - 18	
						QC 7 - 19	
						QC 7 - 2	
						QC 7 - 28	
						QC 7 - 3	
						QC 7 - 30	
						QC 7 - 34	
						QC 7 - 36	
						QC 7 - 37	
						QC 7 - 41	
						QC 7 - 47	
						QC 7 - 48	
						QC 7 - 51	
						QC 7 - 58	
						QC 7 - 59	
						QC 7 - 60	
						QC 7 - 9	
						QC 7 - 68	
						QC 7 - 50	
						QC 7 - 67	
						QC 7 - 40	
						QC 7 - 24	
						QC 7 - 43	
						QC 7 - 61	
						QC 7 - 81	

170 Skidtubes - 3 - B4B	1 pcs	8/30/19	0.00 1.72	Skidtubes - 1 - B4B	DO
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
180 QC 5	1 pcs	8/30/19	0.00 0.00	QC 5 - 10	BE
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
185 Skidtubes - 4 - B4B	1 pcs	8/30/19	0.00 3.44	Skidtubes - 1 - B4B	TF
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
188 QC 5	1 pcs	8/30/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
210 Handfinish - 2-1 Pressure-B4B	1 pcs	8/30/19	0.00 0.62	Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
220 Spray Paint - 2 - B4B	1 pcs	8/30/19	0.00 0.78	Spray Paint - 1 - B4B	
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	

230 QC 14	1 pcs	8/30/19	0.00 0.00	Spray Paint - 4 - B4B	
				QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
260 Handfinish - 4-1-Assembly- B4B	1 pcs	8/30/19	0.00 0.62	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
270 QC 5	1 pcs	8/30/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
300 Packaging 3-1 - Stock - B4B	1 pcs	8/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	

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				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
310 QC 21 - SA	1 pcs	8/30/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 120 - Skid tubes -1- Cut Aft end as per dwg D4766 2- Deburr ends 3-Drill Aft & Fwd Cap holes using DT8678 & Descriptions: DT8901***DO NOT OPEN AFT CAP HOLES*** 4- Locate DT Pilot Drill all X-Bolt holes using #30" drill. & Drill Ground wire hole on top of Tube. 5-Drill holes for D5520-1 doubler using DT10309 A & B, locating from 7th and 8th crossbolt holes from aft using .1875 clekos. Spot drill tube using #20 drill (note 10). Remove DT10309 B. Re-install DT 10309 A drill thru tube and doubler using #20 drill (note 10), cleko as you go. Remove .1875 clekos and open holes in tube and doubler to 0.750". Remove doublers and identify orientation. 6-Countersink rivet holes in skid tube detail M ***NOTE*** 29 places only. 6- Open ground wire hole .297" section D-D (1) place and detail "I" (2) place. 7- Open Aft & Fwd Cap holes using 0.208" drill. 8- Deburr holes. 9--Touch up alodine on D5520-1 doublers.

140 - QC5- Inspect part completeness to step on W/O

150 - Chemical Conversion Coat per QSI005 4.1

160 - QC7-Inspect Chemical Conversion Coat

170 - 1-Install doublers using DT10309 B. Shave rivets as required. Detail M. 2- Bond web as per Dwg D4766 & QSI 015 A/R 241 Sike Flex Batch: 5200025 Exp Date: 07/25/20 start time: _____ end time: _____

***NOTE, 35.9" FROM AFT END AS PER DWG D4766. SHEET 6

180 - QC5- Inspect part completeness to step on W/O

185 - Skid tubes - 1- Bend aft tube as per dwg VERIFY HEIGHT and record: 8.594 (19/32) 2- Remove bending mark and mark centerline on end of tube 3- Drill AFT float holes using DT _____ A,B,C. 4- Open X-Bolt holes to size as per Dwg D4766 and detail K 5- Drill Rivet Holes as per Dwg D4766 Using DT10065 6- Deburr Rivet holes & 0.750" holes and touch up alodine rivet holes only. 7- Seal all faying surfaces using proseal and rivet Doubler as per Dwg D4766. A/R Proseal Batch: _____ 12H CURE TIME START TIME: _____ NOTE: SHAVE RIVET AFTER 12HRS CURE TIME. 8- Ream holes to finish size and Swage x-bolt spacers as per Dwg D4766 and section C-C 9- Trim/Grind flush per QSI 002 10- Swage x-bolt spacer as per dwg D4766 section G-G. Trim and grind flush. Open thru holes 0.625". 11- Deburr and blow out chips from inside of tube.

188 - QC5- Inspect part completeness to step on W/O

210 - Pressure Wash per QSI005 4.3/ Clean and remove all markings - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

220 - Spray Paint / NDT Room - 1- Apply Primer as per QSI 005 4.2.1.3.3 and dwg A/R Primer

Batch: _____ 2- Paint White as per QSI 005 4.2.2.4 and dwg A/R Paint Batch: _____

230 - QC14- Inspect Spray Paint

260 - 1- Install Ground Wire inserts as per Dwg D4766. 2-Inspect for Foreign objects 3-Wet Install hose shield D5534-1 section P-P and note 12. A/R Proseal Batch: _____ 12H CURE TIME START TIME: _____ NOTE: SHAVE RIVET AFTER 12HRS CURE TIME. 4- Install Fwd & Aft caps as per Dwg D4766 and Detail "A" & "B". Fastener must be install wet as per note (9). A/R 241 Sika Flex Batch: _____ Exp Date: _____ 5- Wing Walk as per Dwg D4766 and QSI 005 4.4 Batch: _____

270 - QC5- Inspect part completeness to step on W/O

300 - Identify as per dwg & Stock Location: _____

310 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4766-041-BENT	Extrusion Bent	1 pcs (1 ea)	120-Skidtubes - 1	S207374 S172448 S157507 B146172
D5520-1	Doubler	2 pcs (2 ea)	120-Skidtubes - 1	
CR3212-5-05	Rivet	58 pcs (58 ea)	170-Skidtubes - 3 - B4B	
CR3213-5-06	Cherry Rivet	10 Ea (10 ea)	170-Skidtubes - 3 - B4B	
D5085-1	Web	1 pcs (1 ea)	170-Skidtubes - 3 - B4B	
D5534-1	Hose Shield	2 pcs (2 ea)	170-Skidtubes - 3 - B4B	
D2973	Cross Bolt Spacer	2 pcs (2 ea)	185-Skidtubes - 4 - B4B	
D4686-1	Spacer	11 pcs (11 ea)	185-Skidtubes - 4 - B4B	
D4753-1	Doubler	22 pcs (22 ea)	185-Skidtubes - 4 - B4B	
D5304-1	Crossbolt Spacer	2 pcs (2 ea)	185-Skidtubes - 4 - B4B	
MS20601-AD4W3	Rivet	44 Ea (44 ea)	185-Skidtubes - 4 - B4B	
AELS-1032-130	Rivnut	3 Ea (3 ea)	260-Handfinish - 4-1-Assembly-B4B	
AN3C4A	Bolt	3 Ea (3 ea)	260-Handfinish - 4-1-Assembly-B4B	
AN3C5A	Bolt	2 Ea (2 ea)	260-Handfinish - 4-1-Assembly-B4B	
AN526C1032R10	Screw	2 Ea (2 ea)	260-Handfinish - 4-1-Assembly-B4B	
D2965	Cap	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	
D2965-3	Cap	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	
NAS1149C0332R	Washer (AN960C10L)	5 Ea (5 ea)	260-Handfinish - 4-1-Assembly-B4B	

Job Allocations

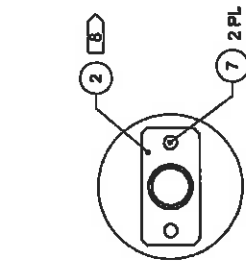
Operation	Component Part	Required	Inventory	Allocated
120-Skidtubes - 1	D4766-041-BENT	1	1	0
	D5520-1	2	16	0
170-Skidtubes - 3 - B4B	CR3212-5-05	58	670	0
	CR3213-5-06	10	59	0
	D5085-1	1	1	0
	D5534-1	2	0	0
185-Skidtubes - 4 - B4B	D2973	2	18	0
	D4686-1	11	21	0
	D4753-1	22	22	0
	D5304-1	2	17	0
	MS20601-AD4W3	44	170	0
260-Handfinish - 4-1-Assembly-B4B	AELS-1032-130	3	55	0
	AN3C4A	3	880	0
	AN3C5A	2	862	0
	AN526C1032R10	2	69	0
	D2965	1	55	0
	D2965-3	1	45	0
	NAS1149C0332R	5	2,694	0

Part Specifications

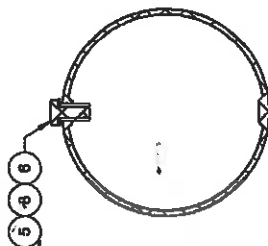
Specifications could not be found.

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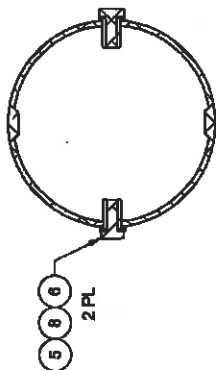
ITEM	QTY	PIN	DESCRIPTION
1	443		SKIDTUBE SUB ASSY
2	11	D4688-1	SPACER
3	22	D4753-1	DOUBLER
4	1	D4769-045	SKIDTUBE SUB ASSY
5	2	D5304-1	CROSSBOLT SPACER
6	3	AN3-1032-130	INSERT
7	3	AN3-4A	BOLT
8	44	MS20601AD4W3	RIVET, BLIND, CSK
9	3	NAS1148C332R	WASHER



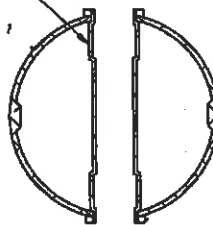
DETAIL E
SCALE 8X
22 PL



SECTION D-D
SCALE 8X



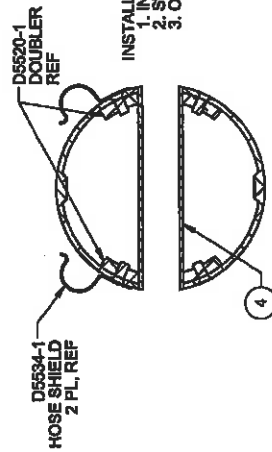
SECTION F-F
SCALE 8X



SECTION C-C
SCALE 8X
11 PL

INSTALL D4688-1 SPACER AFTER INSTALLING D4763-1 DOUBLERS AS FOLLOWS (11 PL)

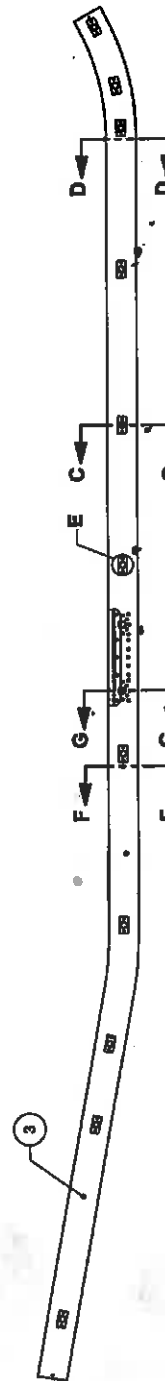
1. INSERT D4688-1 SPACER
2. SWAGE TO $\phi 0.650 \pm 0.010$ X 1.0 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



SECTION G-G
SCALE 8X
2 PL

INSTALL D5304-1 SPACER AS FOLLOWS (2 PL)

1. INSERT D5304-1 SPACER
2. SWAGE TO $\phi 0.585 \pm 0.005$ X 1.0 DP PER QSI 002
3. OPEN THRU HOLE TO $\phi 0.625$



D4766-043 SKIDTUBE SUB ASSY

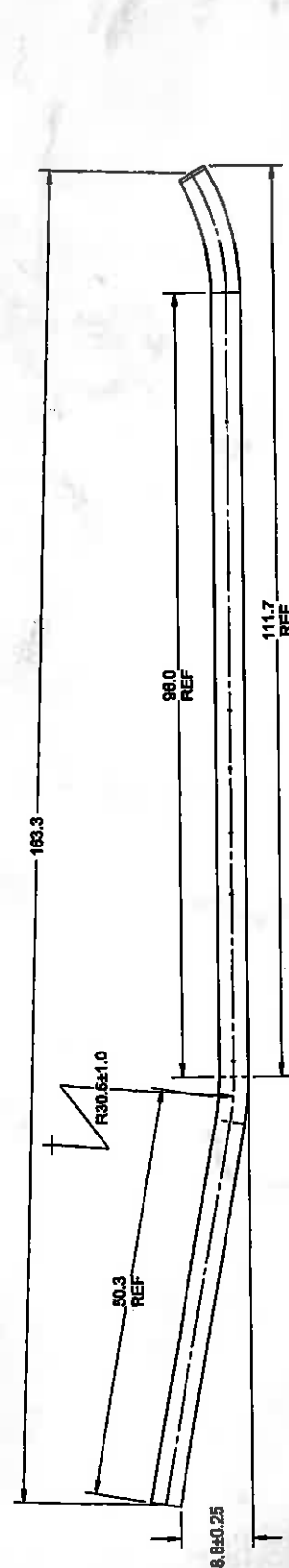
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 33.9 lbs
 - 8) SEAL FAYING SURFACES USING PROSEAL P/S 860/1422 OR MIL-S-8802 CLASS B2 SEALANT

RELEASED
2017-08-11

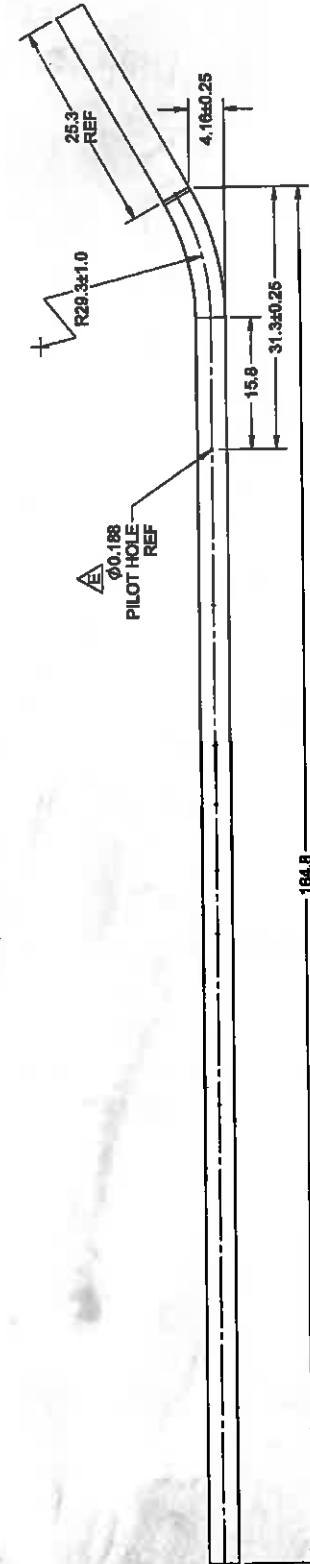
DESIGN	AP	DART AEROSPACE USA, INC.
DRAWN	AJS	EUGENE, OR
CHECKED	ML	DRAWING NO.
MFG. APPR.	DP	D4766
APPROVED	WM	TITLE
DE APPR.	DS	SKIDTUBE
DATE	17.03.30	REV. E
		SHEET 3 OF 7
		SCALE
		NTS

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1 2 3 4 5 6 7 8



D4766-045 SKIDTUBE SUB ASSY
(BENDING DETAIL, AFT BEND)



D4766-045 SKIDTUBE SUB ASSY
(BENDING DETAIL, FWD BEND)

DESIGN	AP	DART AEROSPACE USA, INC.		
DRAWN	AJS	EUGENE, OR		
CHECKED	ML	DRAWING NO.	REV. E	
MFG. APPR.	DP	D4766	SHEET 1 OF 7	
APPROVED	WM	TITLE	SCALE	NTS
DE APPR.	DS	SKIDTUBE		
DATE	17.03.30	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC.		
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8 7 6 5 4 3 2 1

D C E A

Ø0.287
TOP SIDE ONLY

149.00

Ø0.188
THRU
7 PL

35.38

18.78

190.0
98.11
91.03
83.11
75.56
58.10
0

D4766-1 SKIDTUBE

- NOTES:
- 1) MATERIAL: MAKE FROM D2862-180 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART BIN PER QSI 044 METHOD 6.4 ON INNER RADIUS OF AFT END OF SKIDTUBE
 - 7) WEIGHT: 18.97 lbs

DESIGN	AP	DART AEROSPACE USA, INC.	
DRAWN	AJS	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. E
MFG. APPR.	DP	D4766	SHEET 7 OF 7
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	SKIDTUBE	NTS
DATE	17.03.30	COPYRIGHT © 2015 BY DART AEROSPACE USA, INC.	
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N 2017-08-11
APPROVED

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____		DISPOSITION		DEPARTMENT/PROCESS		Engineering ☒ Water Jet ☐ Supplier ☐ Quality ☐	
Part No. _____		Rework ☐ Scrap ☒ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	
Date: 19-09-18	Sequence #: 185	QTY Affected: 1		MRB (051042) 68 9-89 SEP 18 2019			
Description Work Order Deviation		Disposition					
PART NOT MADE TO THE CURRENT REVISION		SCRAP					
Completed By		Lead hand / Supervisor <i>WV</i> 19-09-18					
QC / QA Coordinator		68 9-89 SEP 18 2019					
Root Cause		FAULT CATEGORY					
Operator ☐		Pressure/Forced ☐		Contamination ☐		Positioned Wrong ☐	
Manufacturing Process ☐		Bending ☐		Misaligned/off center ☐		Outside Tolerance ☐	
Equip/Tooling ☐		Crushing ☐		BOM/Route ☐		Drawing ☒	
Handling/Preservation ☐		Cracks ☐		Broken/Damage/Defect ☐		Finish ☐	
Material ☐		Crimp/Kink/Ripple/Wave/Twist ☐		Incomplete/Unclear Instructions ☐		Part Lost/Missing ☐	
Product Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Misread ☐	
Process Improvement ☐		Mislabeled ☐		Fit/Function ☐			
Human Factors ☒		Other/Details:					